

Date: Monday, 01/10/2007 9:24:50 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D350-600-142
Job Number	: 34918		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D350600142
This Issue	: 01/10/2007 S.O. No. :	Drawing Number	: RTN 564
Prsht Rev.	: NC	Project Number	:
First Issue	: // Type : SMALL / MED FAB	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 08/10/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 564

2007-10-01

2.0 D350600142

SPACEPOD, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 SPACEPOD, RH
 ORIGINAL B/N 28993 @ CHG 002

3.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

-DISASSEMBLE D3186-2 DOOR & D3188-2 BODY

-DISCARD ANY PAINTED HARDWARE AND SEAL D2464-125

-KEEP THE FOLLOWING PARTS TO RE-ASSEMBLE :

2 X D2179 B26077 → No good → Replace B30630 X2

2 X D2228 B24560 → 2 good

3 X D2237 B28288 → STILL ON POS - GOOD

3 X D2586 B29021 → 3 good

1 X D2588 B24637 → 1 GOOD

3 X D2621 B27252 → 3 GOOD

1 X D2857-1 B26209 → No good

1 X D2857-2 B 26408 → No good

2 X D2977 B14106 → No good Replace B 14106 X22 X D2978 B21495 → No good Replace B 21495 X21 X D2982-041 B27507 → DID NOT FOUND Replace B254761 X SL69BS B16948 → DID NOT FOUND Replace M106939 *JAN*

*This is what
 I found
 08/03/06 and
 after 5 months
 on shelf.*

07-11-01

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Seq. #: Machine Or Operation: Description :

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(PTU) See last page.

Comment: HAND FINISHING RESOURCE #1

-SAND COMPLETE SURFACE OF DOOR & BODY
WITH 320 GRIT PAPER

-PRIME GREY WITH DUPONT PRIMER
PER QSI 005 4.2

FT 08 03-03

5.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

08/03/04 FL

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

-WING WALKK D3188-2 BODY AS PER DWG

M106894

FL 08/03/05 ①

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AD

08-03-05

(X1)

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

RE-ASSEMBLE PER DRWG
USING ITEMS DISASSEMBLED ON SEQ. 2
PLUS PICK THE FOLLOWING:

ml 08/03/07

9.0 D2464 3/4 Seal



Comment: Qty.: 10.4100 f(s)/Unit Total: 10.4100 f(s)
3/4 Seal
D2464-125 " B

B35433

ml 08/03/06

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/07 ④

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Part Number: D350600142

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	A3235020935	Washer - Countersunk
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 A3235-020-935 Washer

already on pool
N/A
ml 08/03/05

12.0	AN526C832R9	Screw
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Comment: Qty.: 12.0000 Each(s)/Unit Total: ~~12.0000~~ Each(s)

Pick:

Qty Part Number Description Batch
12 AN526C832R9 Screw B106918 ~~X12~~ *X12*

Need

ml 08/03/06

13.0	AN960JD10	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 AN960JD10 Washer M106552 *X3*

ml 08/03/06

14.0	AN960JD516	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN960JD516 Washer M106654 *X1*

ml 08/03/06

15.0	AN960JD8	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total: ~~16.0000~~ Each(s)

Pick:

Qty Part Number Description Batch
16 AN960JD8 Washer M106918 *X16*

Need 16

ml 08/03/06

Need 1x D 3015-3 B36794
(Not on the list)

ml 08/03/06

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Part Number: D350600142

Job Number:



Seq. #:

Machine Or Operation:

Description:

16.0

AN960JD8L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960JD8L Washer M 6956

ml 08/03/06

17.0

MS20426AD45

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 MS20426AD4-5 Rivet

N/A ml 08/03/05

18.0

MS21042L08

Nut



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part Number Description Batch

14 MS21042L08 Nut (or -8) M 106612

OK Need 14

ml 08/03/06

19.0

MS21042L3

Nut



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS21042L3 Nut (or -3) M 106242

Need 3

ml 08/03/06

20.0

MS270390810

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-0810 Screw M 5865

Need 2

ml 08/03/06

21.0

MS27039125

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS27039-1-25 Screw M 17570

ml 08/03/06

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Seq. #:

Machine Or Operation:

Description :

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Wing Walk

08/03/07

23.0

K10018

Spacepod Hardware Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Original:
K10018 B29237

PW

Pick: Packing Kit

Qty Part Number

Description

1 K10018

Spacepod Hardware Kit

1 D3187-2(Ref)

Spacepod Floor

Batch
32698
23405

8/3/11 54

24.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/03/11

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-142 CHG 002

Location:

PPP Rev:

D

PAPERWORK & LABEL @ CHG 002
08.03.10

8/3/11 54 (1)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/12 (1)

Job Completion


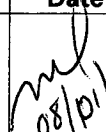
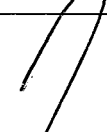

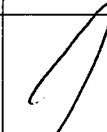

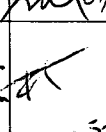
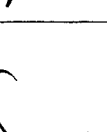
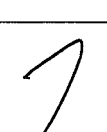
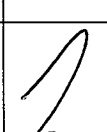


2008/3/11 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-600-142 PAR #: N/A Fault Category: Supplier / Delistok NCR: (Yes) No DQA: W Date: 08/03/12
 QA: N/C Closed: H Date: 08/03/12

NCR: 34918		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-11-15	4.0	The top corner of the Pod Body was sanded too much, and too much glass cloth was removed. R.C. Human error.		Remove all paint - primer around void. Repair void per QSI037 9.7. Record Material used: See Sheet attached	 08/01/14			
↓	↓	h		Remove all paint - primer around void. Sand, and ensure a smooth finish with <u>no voids</u> , or pin holes Prime - paint per QSI037	 08-03-11	 08/03/04		

NOTE: Date & initial all entries

DART

w/o 34918

Re-work for ~~the~~ crack in the corner of
pod D350-600-142 (original B/N 28993 CHG002)

- Drilled 3 holes for stopping crack
- fill up with Hypol 9309 N/A M103866
Exp: 19 March 2008
- mixed 10% of milled fiber M100 859
- let cure 24 hours before complete job

mfo 7/12/17

08-07-17
251207